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U/R

6F9540V00231
Job Sheet 186764



Part No: 6F9540V00231

Job Qty: 1 ea

CONCESSION REQUIRED

Part Name: AW169 Lower Cutter Installation Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/18

Job Tracking No:

Due Date: 1/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF16-692 DWG IIN-D169-841 REV D IPP REV:A 13.11.13 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/25/19	1/25/19	0.00	0.00	Start Up Stores/Pkg-2		9-89 69 DAS 9-89 69 DAS
100	Packaging	1 pcs	1/25/19	1/25/19	0.00	0.00	Packaging1-6		9-89 69 DAS 9-89 69 DAS
105	QC	1 pcs	1/25/19	1/25/19	0.00	0.00	QC4		9-89 69 DAS 9-89 69 DAS
120	Packaging	1 pcs	1/25/19	1/25/19	0.00	0.00	Packaging3-1		9-89 69 DAS 9-89 69 DAS
125	DC	1 pcs	1/25/19	1/25/19	0.00	0.00	DC		9-89 69 DAS 9-89 69 DAS
130	QC21-FG	1 Ea	1/25/19	1/25/19	0.00	0.00	QC21		9-89 69 DAS 9-89 69 DAS

Part Op 120 - Identify and pack for shipping as per PPP 6F9540V00231

Descriptions: 125 - Photocopy blue file per PPP D169-841-015 chg002 and create labels per 6F9540V00231-CHG002

Job BOM

Part / Item	Component Name	Quantity	Operation
D169-841-015	AW169 Lower Cutter	1 Ea (1 ea)	90-Start up Operation

POSITIVE RECALL
EFFECTIVE 12/11/22 AUTH 5
RELEASED 19-02-05
DATE 19-02-05
5/4/11/3

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D169-841-015	1	0	0

Part Specifications

Specifications could not be found.



Container No: S147044



Part: 6F9540V00231

Job No: 186764

Serial No/Batch: S147044

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 01/23/19

Plex 11/21/18 9:15 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

LEONARDO HELICOPTERS		Supplier Concession				PAGE 1 of 2	PLANT Vergiate	
Supplier NC N.	AWC-013/00	Date	28.01.2019	AW Concession	400000079574	Purchase Order	4801861243	
P/N	6F9540V00231			Grade/Category	NC	Drawing Issue		
Part Description	PROTECTR, CCP ASSY LOWER			Batch Quantity	4,000	Defective Quantity	4,000	
AW NC	MARCO FRANCESCONI					A/C Type/Model	AW6	
Supplier	DART AEROSPACE LTD					Contract		
Defect MA01 - Items or materials different from requir - S/N S147044, S147074, S147077, S147079 * 28.01.2019 17:40:26 MARCO FRANCESCONI (39978) * SEE SUPPLIER ATTACHED DOC. AWC-013 Cause of Defect								
					Repetitiveness (same P/N - Defect Code)	NO ☐	YES ☒	Follow (5)
ENGINEERING Evaluation and Proposal								
Engineering Evaluations, including Specialist inputs:				Investigation Report n.	Compliance Report n.			
* 04.02.2019 18:51:07 MARCELLO STEFANELLI (9273) * Acceptable to use as is, as for evaluation in the annex.								
Classification of Deviation from Type Design i.a.w. EASA Part 21A.91 : Minore/B								
Defect effect					Limitations			
	Before Repair		After Repair					
Safety	☐	YES	☐	YES ☐ NO	☐ YES (to specificity) ☒ NO			
Life or Duration	☐	YES	☐	YES ☐ NO				
Strenght	☐	YES	☐	YES ☐ NO				
Performances	☐	YES	☐	YES ☐ NO				
Interchangeability	☐	YES	☐	YES ☐ NO				
Reliability	☐	YES	☐	YES ☐ NO				
Maintainability	☐	YES	☐	YES ☐ NO				
Installability	☐	YES	☐	YES ☐ NO				
Testability	☐	YES	☐	YES ☐ NO				
Only Appearance	☐	YES	☐	YES ☐ NO				
No Effect	☒	YES	☐	YES ☐ NO				
Repair Proposal:					Decision			
					☐ Use rep. with spec.repair(not yet applied) ☐ Use repaired with known repair(yet applied) ☒ Use As Is ☐ Use repaired for tests only(see Limitations) ☐ Use As Is for tests only(see Limitations) ☐ Scrap			
Concession Classification		☐ MAJOR ☒ MINOR		Re-submit after Repair		☐ YES ☒ NO		
Mark part with Concession		☒ NO ☐ YES		Method :				
ATE	MARCELLO STEFANELLI			CPE			Date	04.02.2019
Checks and tests to be performed								
Repair registration		with repair WO ☐ Number:						
Repair Evaluation:								
Final Decision								
S/N	Use As Is (UTI)	Use Repaired (R/L)	Scrap (SCA)	S/N	Use As Is (UTI)	Use Repaired (R/L)	Scrap (SCA)	
S147044	☒	☐	☐		☐	☐	☐	
S147074	☒	☐	☐		☐	☐	☐	
S147077	☒	☐	☐		☐	☐	☐	
S147079	☒	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
Not Serialized	Use As Is (Q.ty)	4,000	Use Repaired (Q.ty)		Scrap (Q.ty)			
Role	AW ATE	AW CPE	Inspection Clearance Repair	Quality	Customer	MoD or Authority Representative		
Signature	MARCELLO STEFANELLI			MARCO FRANCESCONI				
Date	04.02.2019			05.02.2019				

Supplier NC N.	AWC-013/00	Date	28.01.2019	AW	400000079574	Purchase Order	4801861243
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DEFECT 0001 **MA01** *Items or materials different from requir*
S/N S147044, S147074, S147077, S147079

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DEFECT CAUSES

* C41 Material did not comply with specificati

 AgustaWestland A Finmeccanica Company		CONCESSION				Pag. 1 of 2	
<i>Manuf. Doc. N.</i>	AWC-013	<i>Date</i>	Jan 25. 2019	<i>AW Doc. N.</i>	400000079574	<i>Purchase Order</i>	4801861243
<i>AW P/N</i>	6F9540V00231	<i>S/N / Batch Number</i>	SI47077 SI47079 SI47044 SI47074	<i>Grade</i>	A	<i>AW Drawing Issue</i>	B
<i>Description</i>	Protector, CCP Lower Assembly			<i>Batch Q.ty</i>	4	<i>Defective Q.ty</i>	4
<i>Manufacturer</i>	Dart Aerospace LTD			<i>Model</i>	AW169		
<i>Defect(s) Description</i>							
The grain direction on the D4842-1 (D4842-041 Lower Cutter Deflector), P/N 6F9540V0231. Deflector was deviated from the approved Data. The proposed change to the drawing is attached in engineering evaluation.							
				<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>
				Quality Assurance	DAS-16-9-89	P. Duval	Jan 25, 2019
<i>Defect(s) Cause</i>							
Dart Hawkesbury Design Engineer has modified the approved drawing to allow for manufacturing to minimize in material waste.							
				<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>
				Quality Assurance	DAS-16-9-89	P. Duval	Jan 25, 2019
<i>Corrective Action</i>						<i>Complete Before</i>	
Dart Aerospace HBY requesting drawing update to allow for grain direction change on D4842-1							
				<i>Department</i>	<i>Inspector</i>	<i>Signature</i>	<i>Date</i>
				Quality Assurance	DAS-16-9-89	P. Duval	Jan 25, 2019

For "MANUFACTURER" SUPPLIERS ONLY

ENGINEERING evaluation and proposal

Engineering evaluation

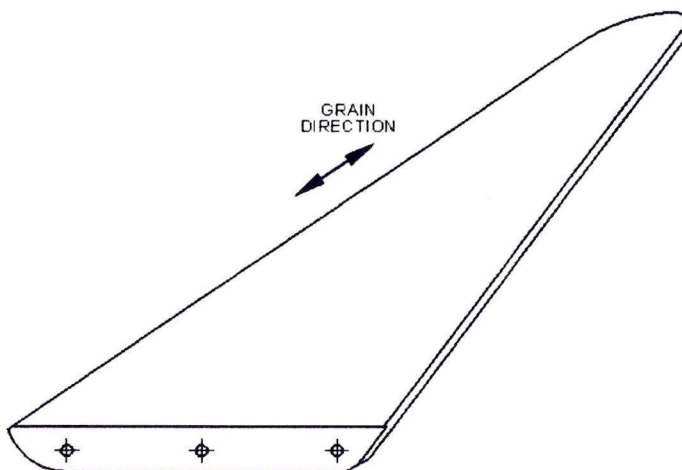
Investigation report

n: NCR18-6764

Compliance report

n... N/A.....

Grain direction was rotated 56° to align with the leading edge of the deflector. This orientation allows for a smaller raw material blank size and significantly reduce material scrap. The grain direction is still effectively perpendicular to the bending plane from cable loads. The effect on strength is insignificant.



Defect effects			Limitations
	Before any repair	After any repair	
	☐ yes	☐ yes ☐ no	☐ yes (specify) ☒ no
Safety	☐ yes	☐ yes ☐ no	
Life	☐ yes	☐ yes ☐ no	
Strength	☐ yes	☐ yes ☐ no	
Performances	☐ yes	☐ yes ☐ no	
Interchangeability	☐ yes	☐ yes ☐ no	
Reliability	☐ yes	☐ yes ☐ no	
Maintainability	☐ yes	☐ yes ☐ no	
Installability	☐ yes	☐ yes ☐ no	
Testability	☐ yes	☐ yes ☐ no	
Only aspect	☐ yes	☐ yes ☐ no	
Repair Proposal			Decision to use ☐ Use repaired with specific repair ☐ Use repaired with known repair ☐ Use as is ☐ Use repaired for tests (see Limitations) ☐ Use as is for tests (see Limitations) ☐ Scrap
Concession Classification	☒ Major ☐ Minor	Submit after repair	☐ yes ☐ no